Notebook Series -- Notebooks by Edison and Other Experimenters
Disc Record Book No. 17
Notebook, N-16-07-21

This notebook was used by Edison during July-September 1916 for notes on experiments to improve the surface quality and the durability of disc records. There are also notes by Archie D. Hoffman and other experimenters. The entries pertain primarily to experiments 1238E through1261E. Included are tests involving different presses and varnish compounds, as well as variations in the amount of heat and pressure during baking. Flaws and successful results are both noted. A notation on experiment 1257 indicates that the resulting blank "appears to be the best blank and record we ever had & should be made standard." Also included are two lists of flaws observed in discarded record molds, numbered 41-199 and 1-48. At the end of the book are notes on the number of "girls" employed in the Disc Department, as well as notes about piece work rates, inspection standards, the number of records and molds produced, the number of discards, and the results of "drop tests." Some notes are in the form of instructions to Hoffman. Inserted into the book are several communications addressed to Edison from G. H. Baldwin, Joe Miller, and John F. Ott. The front and back covers are labeled "17." The pages are unnumbered. Approximately 100 pages have been used.

Old Transfer Records - Listened July 21

Run out slight surface

Light RO all thru

" "

OK

Injury Repeat

VV good RO 1/2 wrong

VV good RO 1/2 wrong

VV good no RO

VV good Light RO

~~Bad surface (sand surface)~~

RO all wrong thru

RO 1/2 wrong Repeat bad sound at start & poor start wrong cut

Light RO 1/2 wrong cut

Bad RO all thru

Light RO

1/2 wrong thru - can't find it -

Harrell & RCut ccc wrong thru Perfect

sounds like 3 short snaps close together -

Bingo - Very good surface no RO or snaps Loud bad start

Loud Bangs - Dance

" " "

Loud Band

fair surface slight RO

Big RO - very all thru

big snap surface fair

C13

Daily Halpin rejections —

21st

Tested 45 Records 9 Rejected —

1st Snap — hole in blank

2 2 snaps — 1 .018 Pullout 1 .007 Pull out Varnish

3 1 group 4 moderate snaps — passed — very to Mould

4 5 Big snaps — in group — bubbles in Var. broke

5 Eccentricity — OK —

6 — Center hole too small —

7 Low spot, ok. hardly notice it

8 Eccentricity OK —

22 July

46 — 5 Rejected — bad inspection, on reject —

23 July

19 — 1 Rejected, Rough surface only bad on start
Radial scratches on smooth a 1st 1/2 inch
other part OK —

26th - Tested 45 — Rej 5 —

27 45 — 3

July 26 1916

We find that rough start & final rejection of mould due to rough surface is due to putting blank on Mould without a pin — The men lay them on & move them this puts in radial scratches on smooth part & also on 1st 1/4" of music to 1/2"

By using a ground Matrix & buffer with all scratches out, & by using a long boxwood pin the blank can be put on & record taken off — 50 blanks 50 records without a single scratch or injury to Mould & then 1 revolution of mould at 222 line to Examine under Microscope

The pin is 005 taper made of Boxwood as fcb77 Cant be turned round

[5]

Dropping the boxwood pin on Mould Matrix produces no injury

We noticed that feather duster makes a few fine scratches too fine to be heard on record.
& only 9 of these with 50 blanks put on & taken off -

Evidently Condensate or dust gets on feathers -

---

tested stack of 8 moulds
Records 9 of old mould
9 of new sgr edge

Practically no difference

Hoffman is trying some 'Brass Bright' polish made by Sherwin Williams Co Newark for cleaning moulds to prevent sticking & pull outs —

Hoffman tried Nickel faced moulds, steel highly polished & also matte surfaces but all made pull outs —

He made some Experiments on Warpendency or rather dealing of moulds

Taking out 3 rounds from the same moulds There seemed a coincidence as to dishing —
One moulds gave 20-20-15
another — 3-4-4—

There were others like this — he will make some more test,

Never Worked since Reed

~~27th~~ 23.

C113

July 29/16

This works better under same conditions of weather & all than 1 1/10 Lac

Hereafter Use only 1 Shellac

1238E 1522 Blank

Hoffman

Run through one batch say 400 blanks with 1 Shellac instead of 1 1/10 - & have them all painted under this number &

4 Rounds sent me note pull outs on your moulds as well

Works good

1239-E

OK OK x	OK OK x	OK OK x	OK OK VEN
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK NR x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	VEN	OK OK VEN	OK OK x
OK OK x	OK OK x	OK OK NR x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK NR x
OK OK x	OK OK x	OK OK x	OK OK x NR
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK VEN	OK OK x	OK OK x	OK OK x
OK OK x			
100%	91%	100%	100%
91%	91%	91%	91%

1239 E

Hoffman 400 blanks the fetrex & chalk to be dried to have less than 1% moisture

Run all them & send 4 Rounds to E

See every box

This seems to show dry powder (10) fetrex & chalk dried before mixing

no goods Relays today

OK OK Low 3	OK OK X	OK OK X
OK OK X	OK OK X	1 Ckd
OK OK Low 3	OK OK	OK OK
OK OK X	OK OK X	
OK OK X	OK OK X	OK OK Vent
OK OK X	OK OK	OK OK
OK OK X	OK OK X	OK OK X
OK OK Vent	OK OK X	
OK OK Vent	OK OK X	
	OK OK X	
OK OK X	OK OK X	83%
OK OK X		
OK OK X	OK OK X	
	OK OK X	
100%		
66%	100%	
	83%	

1240 F July 29/16

This is 1201 powder ~~without~~ Para - that is paved & now made up — powder is _____ old

3/16 Revolver blanks used

Keeping this powder has done no harm ~~[illegible]~~ Although technique is changed - they work as good as Regs today

OK OK x	OK OK VEN	OK OK VEN	VEN
OK OK x	OK OK x	OK OK x	VEN
OK OK x	OK OK x	OK OK crk	OK OK x
OK OK VEN	OK OK VEN	OK OK fine crk	OK OK x
	OK OK crk	OK OK VEN	OK OK
OK OK x	OK OK x	OK OK VEN	OK OK x
OK OK x	OK OK x		OK OK x
OK OK x	OK OK VEN	OK OK VEN	OK OK x
OK OK VEN	OK OK x	OK OK x	OK OK VEN
OK OK VEN	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK VEN	OK OK x	OK OK VEN
OK OK x		OK OK x	OK OK x
100%	100%	100%	83%
75%	58%	50%	66%

1241 F

They Edge Easy OK – no trouble

Hoffman Load blanks from Center & Spread so we get soft Edges – 4 Rounds –

test if OK, then Have them Edges & see if they are soft Edges & Edge good Edge all in One machine

41st Record – 3/16 from music out has few very light faint scratches –
Most of the scratches are 3/16 from music & there are thousands of them about 016 long
Notice scarcely a trace of scratches on feed line part – Thinks this technique with Dowel + pins for put on + Tacks off will stop loud start on records

Should find out why any scratches come on or next to music, No reason for any

65th print
few more scratches
but OK – Mould OK yet.
79th had knock in both sides repaired
96th OK – surface about same
not many more scratches near feed line or 1st 6 lines. Haven't any more scratches that had way back
good for 50 or more Prints or more yet
133rd print – about the same as to surface – few knocks at start of Marriage Bells that was on 96th

1242 E

Heart Throb originally most good surface, Marriage Bells upon Golden Bell Condensing mulhorn taken in ~~bottom of horn~~ in copper hill line

New mould, Dowel pins,

New Record moulds in –

These to Go put in a load + printed right along + records saved + sent to Edison –

First heart Throb
23 Scratches probably all old

Marriage Bells
61 scratches probably all old

After 41 Records very few scratches Except near Edge

3/16 Next to music scarcely any

C21

1216-E	96 prints in this Dot.		7/31/12
OK OK VENEER	OK OK ×	OK OK VEN. & Oak	
OK OK ×	P.O. on Music	VEN	
OK OK ×	P.O. on Music		
OK OK VENEER	VENEER		
P.O. on Music	VENEER		
OK OK VENEER	VENEER		
OK OK VENEER	OK OK ×		
OK OK ×	VENEER		
VENEER	OK OK ×		
VEN. P.O. & Oak	Oak		
OK OK ×	OK OK VENEER		
Oak	VENEER P.O. on Music		
	P.O. on Music		
66%	33%		
33%	25%		

1226-E			7/31/12
OK OK × N.R.	OK OK ×	VENEER & Oak	OK OK N.R.
OK OK ×	OK OK ×	OK OK ×	OK OK VENEER
OK OK Oak	OK OK ×	OK OK VENEER	OK OK N.R.
OK OK Oak	OK OK	OK OK VENEER	OK OK
OK OK ×	OK OK VENEER	VENEER	P.O. on Music
OK OK Oak	OK OK ×	OK OK VENEER	OK OK ×
OK OK ×	OK OK N.R. ×	OK OK VENEER	VENEER
P.O. on Red line	OK OK VENEER	OK OK VENEER	OK OK VENEER
VEN Oak	OK OK × N.R.	OK OK Oak	OK OK ×
OK OK VENEER	OK OK VENEER	VENEER	OK OK VENEER
OK OK N.R.	OK OK N.R. ×	OK OK VENEER	OK OK VENEER
	P.O. on Music	OK OK VENEER N.R.	OK OK VENEER
83%	91%	75%	83%
41%	58%	8%	41%

C25

1238-E 7/31/16

OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK NR x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK finish	OK OK x	OK OK x
OK OK x NR	OK OK x	OK OK NR x	OK OK x
OK OK x NR	OK OK	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x	OK OK VENEER
OK OK x	OK OK x	OK OK fine ok	OK OK x
100%	100%	100%	100%
100%	91%	91%	91%

This experiment while Reqs with 1 to Shellac are sticking bad + giving low % of perfect. 1% Shellac is dry enough so Hoffman reports they dont stick to mould — also that dont crack so bad in records give high % perfect in print whereas today Reg 1/10 Lac are breaking + Causing high % Veneer pullouts

1243 E Hoffman

Few blanks 7 chalk 1

Shellac for Entomologists

blank Sept

Special Graphite Blanks 3 Rounds 8/1/16

OK OK x	crk. 8 Blk	OK OK x
OK OK NR x	P.O. on fed lines	OK OK x
OK OK NR x	OK OK VENEER	OK OK VEN.
OK OK x	P.O. on Music	crk 8 Blk
OK OK x	OK OK x	OK OK x
P.O. on music	OK OK Low - 2 + 3	OK OK x NR
OK OK x	OK OK x	Bad Water spot
crk 8 Blk	P.O. on fed lines music	OK OK x
OK OK x	P.O. on Music	OK OK x
OK OK crks	OK OK x	P.O. on Music
crks	OK OK x	OK OK x
OK OK x	OK OK x	OK OK x
75%	58%	75%
66%	41%	66%

1244E

Hoffman

1 Round blanks regular schedule, but hold at 600 for 1/2 the usual time, send to me - Cool 10 min

Calliper for checking

015
035
027
049
042
037
020
025
048
040
050
025
413

0344

1245E

Hoffman:

One second Elements –
Regschedule, but 500 lbs
final – Cool 10 min

Send to me

Calliper for dishing

040
048
042
035
019
045
038
025
030
018
006
058

0337

1246E

Hoffman

1 Round Cylinder -

Reg Schedule Except

400 lbs - held mins & half - Cool 10 min

Send to me

Calipers for Drawing

035
016
035
039
043
006
024
027
038
045
040
038

12 | 386 (32
36
26

.026 average

1247 E

a

Hoffman Made blanks

One round — Bring pressure right up with heat on — hold for 5 min using 600 lbs
Cool 10 min —

Top plate good, bottom a little cloudy — Could use plates again without cleaning — Blanks good surface

1248 Dished —	1247
030	035
050	035
029	043
050	032
043	034
035	035
042	034
035	026
045	055
034	055
045	035
024	032
average 0388	0376

1248 E B

1 Round blanks - Put heat on & bring pressure right up to 1400 lbs for 8 minutes - Cool 10 min

Blank thicker than 1247

Top plate fair - bottom all cloudy - 2 bottoms rough -

Blanks fair surface.

for Calliper see 1247 E

1249 ⅓

LUCK!

One round
Bring Hanks up to
600 lbs Cold, then put
steam on for 3 minutes
Cool 10 min
Moulds clean
good surface on Blanks

Calliper of Blanks			Calliper for chucking
248	242	006	000
267	252	015	000
229	220	009	000
265	248	017	000
252	250	002	006
262	245	017	005
255	240	015	000
257	237	020	012
282	246	036	010
254	250	004	000
250	235	015	006
246	241	005	000
255		13.5	0024
			S S
			1 1

OK OK	OK OK x	OK OK crk	
	OK OK	OK OK Broken Edge	OK OK x
OK OK	crk	crk	crk
OK OK grafitti	crk	crk	OK OK
OK OK Steam on mould	crk	OK OK x	OK OK x
OK OK snap	OK OK	OK OK x	OK OK x
OK OK	crk	OK OK x	OK OK x
OK OK x	OK OK crk	OK OK ✓	OK OK
OK OK	OK OK x	OK OK x	VEN
OK OK x	OK OK x	OK OK x	OK OK fine edge
OK OK x	crk	OK OK x	OK OK
	crk		NOT OK printed Blk.
83 %	50 %	83 %	NOT Chips Edge printed
25 %	25 %	58 %	66 %
			31 %

1249 E

Blanks 4 Rounds
Schedule bring Blanks up To 600 lbs pressure COLD. Then put on Steam for 3 minutes, Then Cool.
These 4 rounds run on 1 set moulds – moulds just as clean as when started –

Little Too soft to porous

1250 E. well probably

62 OK –

See Drip ahead
thicker Bar

1250 F

1 Round.

press to 600 lbs COLD.

then, put on steam and

hold for 6 minutes, Cool 10 min

send to Eaton

Moulds clear

Dished			
006	242	232	010
005	248	243	005
010	251	242	009
000	240	234	002
006	245	230	005
000	248	239	009
010	246	224	021
006	245	236	009
010	255	254	001
006	241	237	004
012	243	230	013
009	248	240	008
0066	246		008

8/4/16

1250-E

OK OK x	OK OK crk.	OK OK crk.
OK OK crk.	OK OK crk.	OK OK x
OK OK crk.	OK OK x	OK OK VEN
OK OK crk.	OK OK x	OK OK x
OK OK fine crk.	crk 0 Blk.	OK OK VEN
OK OK x	OK OK x	OK OK crked
OK OK x	OK OK x	OK OK crk
OK OK Lev-3	OK OK fine crk.	OK OK x
OK OK crk.	OK OK x	OK OK x
OK OK x	crk 1	crk 0 Blk.
OK OK x	OK OK VEN	OK OK x
OK OK fine crk.	crk 1	OK OK x
crk 0 Blk.		No new rounds used
91%	75%	91%
41%	41%	50%

1250E

4 Extra rounds to be kept to see quality 1st 4

Drop 8 Rounds

3 rounds to be painted —

1 Round Varnished so to be saved to look at

Blanks look good Seamless after Varnishing Very good 1/2 are bad dished + 1/2 flat.

CSI

12/58.1

12/126(105

1251E 1 Round

Blanks Double pressed

Req each except 400 lbs, cooled

Put back + req each 600 lbs —

Dished	after 20 hours
000	007
000	000
000	004 cpp
018	000
010	008
015 —	026
015 —	045 —
000	015 —
000	009
000	000
000	000
005	012
	0105

Warm Cooler

Remember Top + bottom plates are dished in many cases several thousandths

Aug 3/16

When blanks show bright spots on one or on both sides opposite it is probably powder was rammed on or water got in powder this gobbed pieces 1/16 to 1/4" together was loaded & then shows up bright — These spots are soft to the knife — When blank dry & are dirt they look gray

~~Slit~~ The Marquin of Wet & dry sometimes causes a puff out in record, showing a circle around the water changed particle —

Cut 25 Records which had raises implying there was a Dent in the ~~[illegible]~~ mould but found there was a soft spot (water) just under varnish which raised varnish after pressure off — these due probably to spittle mark on blank or spittle or rain spray in powder — one big one was piece of bag fabric = not the mould

Notes

Many times we find a record with 1/8 to 1/4 circle on record the Edges which show puff out which makes it conspicuous.

This is due to a putty like soft combination of Chalk & shellac only = We find these shiny spots on blanks —

This material gets in powder from Dead End in mixer — & the powder probably never went over screens

Spots & marks on blank, or water spray on powder, when near surface will raise varnish up & make knacks & generally as deserved, fibre will do the same also woodpulp without shellac,

Blanks should be inspected for fibre or light colored spots -

I do not think there dant the mould,

1249-E	Dup.		8/4/6
OK Ok crks	OK Ok x	OK OK x	OK Ok x
Raised By WATER	OK Ok x	OK Ok crks	crks
OK Ok x	OK Ok x	Poor Margin	OK Ok
OK Ok VEN	OK Ok x	OK Ok x	crks
OK Ok x	OK Ok crks	crks	OK Ok x
OK Ok VEN	OK Ok crks	crks	OK Ok x
OK Ok x	OK Ok x	OK Ok crks	OK Ok x
OK Ok x	OK Ok x	OK Ok x	OK Ok x
OK Ok x	OK Ok x	OK Ok crks	OK Ok x
crks	OK Ok x	OK Ok x	OK Ok VEN
OK Ok crks	OK Ok crks	OK Ok x	OK Ok crks
OK Ok x	OK Ok x	OK Ok VEN	OK Ok x
83%	100%	75%	83%
50%	75%	41%	66%

1249E — Dup.

4 Rounds

Varnished twice. 1st Var then another brushful + immediately Varnished again, 1 bake

Records show scarcely any dishing - 8/10 flat,

[613]

1252

Hoffman

8 Rounds, —

Duplicate of 1249 but

with ~~latest~~ blank One of

Shellac

4 Rounds to go up stairs.

Has 4 Rounds on hand

1 ½ old mould

OK OK X	OK OK X	OK OK clipped	OK OK
OK OK clipped OK	OK OK clipped	OK OK X	OK OK X
OK OK X	OK OK OK	OK OK X	OK OK clipped
OK OK X	OK OK X	OK OK	OK OK not Vent
OK OK OK	OK OK	OK OK X	OK OK X
OK OK OK	OK OK X	OK OK X	OK OK X
OK OK	OK OK clipped	OK OK X	OK OK clipped
OK OK	OK OK	OK OK Vent	OK OK clipped
OK OK X	OK OK clipped	OK OK Vent	OK OK clipped
OK OK Vent OK	OK OK clipped	OK OK	OK OK clipped
OK OK X	OK OK clipped	OK OK X	No clipped
OK OK X	OK OK	OK OK X	OK OK X
			OK OK X
91%	100%	91%	OK OK
50% perfect	25%	58%	OK OK X
			91% 40%

1253.E

1 Lac blank

Varnish 4 rounds, put on one breechful of Varnish all over & then immediately another breechful - Same as 1249 was Varnished

The blanks are porous.

One bake dry —

Print in New ring moulds

One alcohol & ~~[illegible]~~ 600 lbs Cold & only 3 min press so that OK requires 3½ To 4 min Squeeze —

Surfaces are better than Rags nearly every one has a very light Run out hard for me to tear The 3½ @ 4 min pressure time will be better

138th print is OK both sides = 2 very fine times
In 1 Revolution only found 10 scratches
on 1st 18 lines of music 018 To 040 long
very light = practically no scratches
on smooth part where there are a
thousand on Copper with this many
prints —

Think plated Nickel is evidently
not scratched by putting
on ~~these~~ blanks

Notice very little difference between
2nd print & 138th — same little snaps
are in both & final surface
about same — No new snaps
have come in —

Nickeling seems to be an
improvement — Yes 256th show good
but press mottling
Bad —

~~I notice on the [illegible]~~

256 times — Valse Pathetique OK
Crescendo horrible run out, press mottling
cut out —

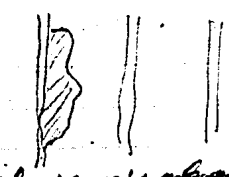
1254 E Press mottling (1E)
amorphous Copper be obliterated
to stop press mottling nickel will
prevent surface wear

Two heavily Nickel plated
moulds — to be put in
a bath & run till
further notice —

Every one sent to Edison

182nd Print — general surface a little crumbly
at start with several big snaps & a big
snap near end — Heavy gouging time —

Valse Pathetique, OK but start kills off —
no scratches on smooth or 1st 18 feed lines except
3 or 4 minor ones — but 1st 18 top of circle
is more mottled than farther in —
One piece Ni pulled off .003 wide .025
long



it wont sound
like is an Hungarian
accent

Nickel is probably an improvement

1255 E

OK OK n.v.old ring X	OK OK X	OK OK X	Cracked
OK OK X	OK OK X	dirtn m	OK OK X
OK OK X	OK OK X	OK OK X	OK OK
OK OK X	OK OK X	OK OK	OK OK
OK OK	OK OK	OK OK X	OK OK X
OK OK	OK OK	OK OK	OK OK
OK OK X	OK OK	OK OK	OK OK
OK OK X	OK OK	wnGr	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK	Dio	OK OK	OK OK
OK OK	OK OK X	OK OK X	OK OK X
OK OK	OK OK X	OK OK X	OK OK X
OK OK	OK OK X		OK OK
11.			
100%	91%	83%	91%
63% perfect	66%	50%	50%

57.2% Perfect, 91.5 general Consol

1255 E

Hoffman 4 Rounds Reg

One Shellac blank, powder

Bring to 600 lbs pressure Cold then put on steam for 4 minutes then Cool. 10 min

Blanks to be varnished all over with one brushfull & then immediately varnished with another brushfull. One bake

To be provided in new square ring moulds

~~filled then~~

1256 E

OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK	OK OK X	OK OK X	1 Cracked
OK OK X	OK OK X	OK OK S	OK OK X
OK OK X	OK OK	OK OK X	OK OK X
OK OK	OK OK	OK OK chip out	OK OK X
OK OK X	OK OK	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK	OK OK X	OK OK X	OK OK X
OK	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	11	OK OK	
100%	100%	100%	91%
75%	82%	75%	91%

97.7 Correct 80.7 perfect

1256 E

4 Rounds Regular. One Checkerboard blank ()

Bring to 600 lbs Cold then put on electric for 5 minutes cool 10 min

Blanks to be varnished all over using one brushfull immediately followed by another brushfull — One bake

To be painted on new square ring moulds.

[71]

1st water not counted -

1257 E

Water -		Water.	
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK low	2
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X	OK OK	X	OK OK	X
OK OK	X	OK OK	X			OK OK	X
11							
100%		100%		100%		100%	
100%		100%		100%		91%	

	3 min	4	5	6
1257 E	91%	91.5	97.7	100
	40	57.2	80.7	97.5

4 Rounds Dup of 1255 but 600 lbs with steam on 6 minutes Cool 10 min

Two brushfuls Pace

Cor ring manual

SEE 4 leafs ahead

Breakties 20-20-20-20-20-20 only tried 20 drops

1255 is filled clear to Edge
1256 nearly filled
1257 without 1/8 showing the break
some filled but majority 1/8

Calliper for diameter w/thickness	Calliper for highest thickness	Lowest	Dished
004			005
009			flat
017			flat
013	207	198	flat
010	222	212	020
002	214	208	012
006	216	211	025
009	219	213	flat
006	215	214	016
010	214	204	020
009	226	213	
	218	201	098
086	212	203	
	218	214	
	214	208	

Edges fine -
Much better than 1255 & 6 Blanks scheduled of
Break Mandrel shell 6 Each one
Edge - or twice to 3 times required run on cycle 6 Control 3 minutes

1258 E

To Gz Calliper for thick + D values

OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	OK OK Low 2	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK Low 2
D in Ckd powdly	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK old + n Ring X	OK OK X
OK OK X	OK OK X	OK OK	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
OK OK	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	Ckd
OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	OK OK X	OK OK X	OK OK X
	OK OK X		OK OK Very low 2
83%	100%	100%	91%
75%	91%	91%	83%
		93.5 85	

~~Kicker up to 1 on Edging~~
~~used 6 on mandrel first 4 mandrels drill 1 cutter used qu~~
~~Blanks much softer than regular cutters~~
1258 E ~~stand up bellow about 1 crack in mandrel~~
~~water put 3 to 4 drops on mandrel they are~~
~~so hard~~

4. Rounds Reg 1 Lac blanks bring up to 600 lbs Cold — then put on steam for 7 minutes, then Cool to room

Print in new square lining mandrels

To Gz Varnished One brushfull of Varnish immediately followed by another brushfull then Bake

Send to Edison

Blank gets too dense + two brushfulls too much makes low spots which are really gas spots

1259-E

OK		OK	OK
OK	OK X	po foodline	OK
OK	OK X		OK X
OK	OK X		OK X
			OK X
OK x	OK X	OK X	OK
OK x	OK X	OK X	OK X
OK x	OK X	OK	OK X
OK X	OK	OK X	OK X
OK	OK	OK X	OK X
OK	OK	OK X	OK low 2
OK	OK X	OK X	OK X
OK X	OK X	OK	OK X
OK X	OK X	OK	OK X
		OK	
100%	91%	75	91%
58%	75%	41%	66
		89.2	
		60	

1259 E

4 Rounds Use regular
1 shellac powder
Bring up to 600 Lbs Cold,
then put on steam for
8 minutes, Cool 10 min

Varnish with one brushfull
of varnish immediately followed
by another brushfull —
Bake

Print in NCWA square ring
moulds —

Send to Eckman

1260 E

Calliper for thick + thin

OK OK X		OK OK X	
OK OK X	OK OK X	OK OK X	OK OK X
OK OK X	OK OK	OK OK X	OK OK
OK OK X	OK OK X		OK OK X
OK OK X	OK OK X	OK OK	OK OK X
OK OK X	OK OK	OK OK	OK OK X
	OK OK X		OK OK
		OK OK	
OK OK X	OK OK Ven	OK OK	OK OK
OK OK old rewring	OK OK X	OK OK	OK OK
OK OK X			Ok 6 Bk
OK OK	OK OK X	OK OK X	Ok 6 Bk
OK OK X			
91% 66%	75% 50%	75 33% 76.7 47.5	66% 41%

1260 E

4 Rounds using regular 1 s. bellac powder –
Bring up to 400 lbs + then put on steam for 8 minutes – Cool 10

Varnish with one brushfull of varnish, immediately followed by another brushfull
Bake –

Print on new square ring moulds

Send to Edison

7= Blank schedule Can vary from 5 mins to 7 min without great variation in discards – This will take care of variations in powder

8= in water 40 min surface not harmed on record
ditto 60 " "
" 2 hour " just perceptible –

Grafite is a very bad thing on blanks – grafite gets in grooves & after a while pulls out & makes a bad knock –

Note

Notes on 1257

1257 appears to be the best blank and record we ever had & should be made standard = 4 wood 3 chalk 1 shellac its the strongest, all dropped 20 times without breaking any of the 6 tried

2nd It is easy to Edge. 4 mandrils 6 each Edged with one single edge which is twice as much as regular, & man reports it will do more.

3 The flatest record yet average dishing .098. Highest to lowest thickness average 216 To 208 average variation of thickness 086.

4 100% Consol perfect 97.75

5= Has nearly twice as much varnish, hence better surface – more waterproof – softer not so susceptible to make dents.

6= Blank moulds keep clean & go several rounds without cleaning give high % & no pull outs

(81)

Mix wrong, or wrong ingredients

OK OK	X	OK OK	
OK OK	X	OK OK	
OK OK	X	OK OK	
OK OK		OK OK	X
OK OK	X	OK OK	X
OK OK		OK OK	X
OK OK	X		X
OK OK	X		X
			X
OK OK		OK OK	X
		V	
OK OK	X	V	
83%		58%	
58%		33%	

Run thru factory quite a greenhorn - Rivetes keepers
Eye inspection 75% OK Inspection 96.1% Edgar 96.2 —
of 240 — only 10 down previously Edgar = They passed XXX Ella Lake

1261 E

Hoffman —

On ~~Monday~~ Tuesday the 14th

Start ½ leg on regular blanks with new blank press schedule and continue till otherwise notified.
Schedule = Put on 600 lbs COL□
Then put on steam for 6 minutes, Cool 10 minutes

These blanks are to be varnished all over with one brushful of varnish immediately followed with another brushfull of varnish Dry + Bake regular

1261 Blanks thus made are all to be printed in new square edge rim moulds. This leg will make about 1200 per day = This output under these conditions is to continue till otherwise notified

Amorphous Copper

324th Run

Start fair -

600th print

Start fair

Its pretty fair - general surface good but too many snap repairs none of them bad or objectionable, but too many for a good record

Off -

Mould of hard Copper -
2 Snaps -

12th surface fair -

36 " better than 12th.

109th = " still better The general surface is very soft & velvet better than any tested for long time - The Mould Originally was damaged bad & they couldnt clean it Had it been a good mould & nickeled it would be perfect. There is many fine snaps but this is due to the defect mentioned

This is a winner

217 prints - good yet surface 3/4 from start. V - balance good -

good yet after 1st inch balance is like ka as seasoned only 75 prints old - all impressions are good & thousands better than have got said off Think it should run 600 times

Mix of Recovered & fresh alcohol
0.830 Spec should be

Proportions = 1522 blank (1238 F)

Varnish for powder

257 lbs 10 oz TN Lac 5 lbs Extra for dust
900 lbs Alcohol
1.3 lbs Para 583.2 grms

Each batch in mixer consists of

57 lbs Wood
43 " Chalk
2 " Lampblack
102 lbs

The above amount of Varnish will make 18 batches of 102 lbs each -

Total 2065 lbs

50% Wood
37.5% Chalk
12.5% Solid Lac

This is 4-3-1 Lac

MH Dia - Moulds

41 - Bruise — Piece sand 026 -

50 Bruise — Tack in blank

51 Dent = 4 big knocks 1/4" from feed line

52 = Dent = Chip in mould 1/4" from feed line

53 - Dent = 18 Prints 2 Dents 1/4 from feed line

54 Bruise - 42 prints - 3 big injuries - Dunniddie found it was mould that leaks

55 Breakle - 63 prints. Nothing on opposite side - tried to repair - NG

56 - Dent = 11 Prints - Tack in blank

57 - Dent - 3 prints - Big piece 3/16 dia white. Cement or quartz. Milky - some part frantic

58 Dent = 72 prints 1/4 from feed line

59 - Dent = 3 prints - 1/4" from feed line

60 - Too Crackly = Its Crackly but this is based on 1st print which is questionable probably 3rd print would show mould was OK

61 = Dent = Big dent radiat stars in smooth - gloss 1/4 in magic 1/16 wide think mould is uninjured -

62 = Bruise = 115 Prints - Quartz - milky 3/16 dia

63 = Dent = 28 prints 1/16 from feed line 020 wide 1/4" long

64 - Breakle - big - Clamp fault

65 - Dent - 36 prints 015 X 1/8 long on feed line

66 - Bruise = a tool or steel has scraped mould bad 1/2 long 030 wide

67 = Label scratches in cleaning - 154 records - should not have been discarded

68 = Big hole = 3 prints - Celluloid defect -

69 = Dent - 29 prints, sounds are weak 3/8 from feed line - should not have been discarded

5147]

70 = Hole + Dent = 40 Prints - hole .020
Sand -

71 = Dent - 3 prints Big Chip $\frac{1}{8}$ x 3/16 - 3/8
from feed line -

72 = Bruise = 13 prints, something
dropped on it.

73 - Dent - 50 prints - small, $\frac{1}{8}$ from feed line

74 = Dent = 217 prints long narrow
dent .020 wide. 3/8 long across
feed line at an angle - clearly a
shoe from piece out

75 = Crape = 40 Prints. Dark
with Moved lock lever

76 = Dent = 79 prints. $\frac{1}{16}$ from feed line
1/16 dia -

77 = Hole - 3 prints - hole in Celluloid

78 - Bruise = 116 prints - Dented
probably by moved lock
both sides alike -

79 = Bruise - 43 prints - .025 @ .030
Sand particle or metal

80 = Knocks + Crackles = Record shows
Crackly but moved should not be
discarded from Sample Record

81 = Loud Surface = 121 prints -
Wrongfully plated - should have
reported - Run Out + Snaps
Also moved discarded from sample
record Thereafter record
moved not shows Run Out +
probably also snaps -

82 Dent - 7 prints fine shoe $\frac{1}{4}$" from feed
.010 wide 3/16 long

83 - Bruise = 38 prints - piece sand or metal forced
in + moved, parallel to Music lines

84 = Big Hole = 99 Prints - Puzzle, 2 holes, sharp Edges looks as if metal Chipped out, no metal displacement -

85 Roughcut Steel = 3 prints - Think Mounted OK - Run Out on 2nd print worse than on 3rd - 1st mounted rough

86 - Rough surface = 122 prints - good surface, should not have been discarded

End of 7th day
45 Discards

8th day Discards -

87 - Dent = 95 prints .030 X .060 1/8 from feed line

88 - Buckles - 7 prints - dirt on holder Clamp fault.

89 - Buckles = 9 prints - dirt on holder - Clamp fault

90 = Crackly = 25 prints only 1 print sent. bad surface correct

91 = Dent = 194 Prints 1/8 from feed line

92 = Dent = 43 prints 3/8 "

93 = Dent - 65 prints 1/16 @ 3/32 piece 1/16 feed line

94 = Dent - 26 prints 1/8 wide 5/8 long clamped 1/16 in smooth part at angle 25° to mine - the piece is in the blank - it was so large it actually Cracked blank

95 - Discard for Mottled surface - Bad scarf

96 = Dent 48 prints 1/32 from feed

97 Dent = 38 prints 3/16 from feed line

98 - Dent 3/8 from feed line

99 = Hole - 53 prints - grit .020 dia

100 - Black hole = 3 prints - Defect in plating dirt or bubble in Copper

101 - Bruise 161 prints, Think it drove to lock pin - .030 long sharp Cut

102 - Mottled surface Cracks 184 prints Bad surface

103 - DEnt = 81 prints 1" from feed line

104 = Bruise - Clean cut, metal cut it - has a radii, its Either pin or lock lever

105 - DEnt = 120 prints 7/8 from feed line

106 = Hole Too large to scrape - 46 prints - 3/8 from feed line - Dis -

106½ DEnt = 266 Prints = 5/8 from feed

107 Hole = 62 prints - plating defect

108 - DEnt - 18 prints - ¼" from feed line .030 X 1/10 inch

109 - Scrape - 51 prints = long scrape very narrow .010 - 1" long

110 = Poor Label, Cracked + Eccentric = 255 prints - its Crackly + 5 Eccentric Discard

111 - DEnt = 61 - prints 5/16 from feed

112 DEnt = 143 prints - Sliver 5/8 from feed line angle 30°

113 - Bruise - 18 prints Sand or metal .018 X .036 Parallel with music

114 DEnt = 245 prints 3/8 from feed line .020

115 - DEnt 54 prints 1/8 from feed .020 X .060

116 - DEnt = 27 prints 1/16 from feed .030 round

117 DEnt - 31 prints - 7/8 from feed 1/16 dia

118 = Injury - 83 prints - Sand particle

119 = Bruise - 44 print Tack in blank

121 - Cracked 148 prints - Bad surf

120 Bucked - 40 print - Clancy - dirt on Mould holder

122 Bruise 117 prints Long scrape Chatter 11 11 11 11 Junk Mould holder struck bottom Matrix

123 - DEnt 101 prints big chip 1/8 X ¼ - 1/8 from feed

124 - Porous Spot - 61 prints - Porous plating defect

End of Dis

39 Discards

Discards on 9th =

125 = Cracky - 85 prints - This mould should not have been discarded - a duplicate of Glass here but another number is many times worse & is allowed to run right along

4744-C-7-111 — 126 - 228 prints - 5/8 from feed 1/16 round Dent.

127 = 2802-B-4-29 - Dents - 5 prints, 2 big dents 1/32 x 1/8 on feed line right angles one 1/16 @ 3/16 dam 1/8" from feed line - Has operated several months

128 4277-C-7-24 - Surface Knocks 170 prints = 5 big scraps but its due to piece Condensate sticking to mould Shows Runout quite bad but this is in the Specific Blank & he should have tried another Blank, only 1 sent when I asked for 2

129 = 4721-C-3-5 = 170 prints = Surface Knocks - Bad surface - old mould holder first 1/2 inch scratched up bad. tops arch flat

130 = 4692-C-2-12 - 83 Prints Bruise = Round dent - Lock pin on Center pin edge

131 = 1285 B 30-37 - 126 Prints DENT Chip 1/16 x 1/8 - 1/2 from feed line - old mould —

132 3655-B-6-61 - DENT. new mould, 99 prints = 020 x 1/16 1/16 from feed

133 = 4311-C-2-64 = New Mould, 53 Prints Shows radial 020 3/16 long at feed line -

134 = 4173-A-33 - old mould - 109 prints Shows - 020 3/16 long 1/4 from feed line -

135 4745-C-4-20, old Mould - 44 Prints 2 dents 3/8 from feed line - 1/32 x 1/8 the other 030 round

136 = 4374-A-1-83 — old Mould : 93 Prints tried to repair = its very small - Should not have been discarded hardly noticeable dozens of moulds running have as bad,

137 - 4037-C-2-64 inside old 1 new on new side where Dented 1 2 pieces 1/4 apart 1/4" from feed 1/16 dia about.

138 - 4154-A-1-34 = New mould side — Dent new mould side — big splint in surface 1/16 wide 5/8 long 5 5 1 of 1/32 1/16 from feed

139 = 4402-C-4-48 — new mould - Dent. 20 prints Sliver 010 - 1/4 long radial - 3/4" from feed line -

140 = 4460-H-2.58 - old mould - 159 prints Bad -

141 = 2352-C-1-9 - Dent = new mould - 123 Prints, Sliver 5/16 long 1/32 dia - nearly radial 1/2 from feed line - End of 9th 17th

Aug 10. Discard -

142 = 4325-C-3-59 = 99 prints of Dent new mould = 3/4" from feed - 1/32 x 1/16 -

143 = 4106-C-8 - Dent - 205 prints - new mould Sliver - radial - 1/4 from feed 020 x 3/8 long

144 = 4402-C-4-51 = Dent new mould — 15 prints = 1/16 from feed - parallel - Sliver 020 - 1/2 long

145 = 2785-B-3-30 - 44 Prints, old mould Dent Sliver 1/4 long 020 - radial 1/16 from feed

146 = 4745-C-4-7 Bubble in repairing - new mould - hardly bear it should not be discarded -

147 = 4382-A-1-7 - Dent 33 print new mould. 1/16 round on feed line -

148 = 4460-H-7-1 - Dent - old mould - 3/4 from feed line - 040 round = 54 prints -

149 = 4460-H-7-2 - Bruise - new mould - 38 prints - grit probably - 1/8 from feed 020

150 = 4129-C-7-51 = Steel in blank reported - 96 print = 020 near label -

151 = 4326-C-3-61 - 5 prints - should not be discarded, wrong was on bridge wall not in back of Diamond 5 prints wrong -

162 = 4685-C-41 — 142 prints Dent - new mould - Chip 1/32 x 1/8 - 3/4 from feed

153 = 4588-C-4-180-86 prints Dent
new mould = Sliver 3/8 long .020 3/8 from feed line —

154 = 4168-C-3-327 - 77 prints —
pressed on a metal piece with radius pressed down -

155 = 3894-C-3-15 = Buckle,
dirt on mould holder - Clancys fault,

156 = 3894-C-3-16 = Dent - not on 1 or 2nd print - (New mould) its on 3rd print - 1/4" from feed - 1/4 long 1/16 wide

157 = 4367-A-7-18 - Dent = new mould ring 3 prints - 1/2 from feed 3/32 x 1/32
might work ↓

~~159~~
158 - 4154-A-1-30 - Dent old mould - 174 prints
.030 x 1/8 - at feed line -

160 2951-G-1-22 - Dent = Pinched 16 —
.015 round - 1/8 feed line —

161 = 3555-C-4-22 - Dent = 142 prints — new mould ring - .020 round 1/16 feed line —

162 = 4382-A-1-21 - Dent 101 prints - old mould ring 1/16 wide 3/16 long at feed line —

163 = 4553-B-8-7 = Bruise = 22 prints -
think one mould scraped over other - forgot blank -

164 = 4326-C-3-82 - Dent - new ring 63 prints
big piece forced in blank 1 1/4" from feed 3/32 wide 1/4 long

165 = 3307-C-3-17 = Dent, new ring - 98 prints on feed line .015 round -

166 = 4158-B-40 - Knocks & Cracks 120 prints rightly demanded

167 = 4015-C-67 - new ring - 22 prints .010 x .050 - 3/8 from feed -

168 - 4494-A-5-70 - Dent, new ring - 16 prints 1/2 from feed line - .015 x 1/8"

169 = 2115-A-2-73 — 78 prints - new ring dirt on backer - Bushing leaks probably -

170 = 3911-C-9-8 – 88 prints, old ring Dent
2 dents 7" apart both 1/2" from feed
one 1/8 long other 1/4 long

171 = 3117-C-8-93. Dent – 222 prints old ring
5/16 long 1/16 wide nearly radial – upper end
1/4 from feed –

172 = 4431-B-33 – Dent – 124 prints – new ring
1/4 long – 1/4 from feed – 040

173 = 4477-C-3-117 = Dent 43 prints new ring
Silver 015 – 3/16 long 1/2 in smooth 1/2 in heavy

174 = 2586-A-1-19 – Hole on Marquin
9 prints – looks like Mercury or lead
forced in

175 = 3280-B-2-35 – Bruise – 136 prints
Cartridge what caused it –

End of 10th Aug 33 Discards

7th & 9th & 10 – how

Dents	68
Bruise	17
Surface	10
should not been discarded	10
Due to Blank	4
Hole	9
Scrape	2
porous spot	1
Buckle	7
	128

Discards 11th Aug

176 – injury – 3 prints = sand, 020 – new ring
piece white grit 1/8 @ 3/16 square –

177 – Dent – 101 prints new ring – 1/8 @ 1/32 1/16 from feed

178 = Crackles – 97 prints, Due to very bad
metal, should never have been put on

179 = Dent = 17 prints – new ring – 1/32 × 1/8
on feed line –

180 = Bruise – 393 prints – 4174-B-14
done by metal on blank 1/32 square – surface ok

181 = trouble to repair – 237 prints – repeats –
Showed full scrapes also a rattling surface
Kept on board too long.

182 – Crackles. 180 prints – some bad scrapes
in record – bad alloy, but general surface
fair to good – The more we wash
this the smoother it gets

183 = Dent – 27 prints – 1/4" from feed 020 × 1/8

184 Metal in blank – 61 prints –
Its a Tack –

185 = Porous Spot – 150 prints –
Something in blank ducks –
or a drop of Cyanide – at another place
grit made injury – or bruise – surface OK

186 Dent = 66 prints – angle 40° chip. 1/16
3/16 long at feed line

187 = Mottled Surface – 56 prints – Horn blk surface

188 Bruise – 59 prints – metal pressed dent
in mouth – metal dent mouth – 030

189 = Dent – 1/8 × 032 angle – at feed new ring 78 prints

190 Scratch = 237 prints – should not
be discarded for the scratch near
label as it far away from the
mouth

191 – Bruise – 107 prints – Radius
bruise – done by man with some
metallic – not due to blank –

192 = Mottled Surface – 187 Prints –
This is not what is called a mottled
surface at all + Run Out has got in mouth
from some previous injury

193 = Scrape 192 prints –
Dont sound – Discarded for
appearance, they should have said so

194 = Mottled surface = 107 prints
Why reject for mottled surface after
107 prints – its a little mottled –
ask Condemnito, There is a big
Run Out on a horribly Cracked
surface why 107 prints before
rejection 4721-C-3-30 –
get others from Bad Lum

195 = Porous Spot – 97 prints OK
Real porous spot developed
from use – its in plating +
tried to repair bad spot afterwards

196 = Knocks + Cracks – 65 prints –
after cleaning twice 75% of
surface disappeared, 3rd cleaning
showed some record –
2 or 3 small chips out of
steel could have been
repaired – Condemnito spoiled
on mouth – small dent +
small injury – 1st 18 lines Scratched bad

197 = Dent = 4 prints – 1/16 dia 1/8 from feed line

198 = Dent – Cracks & Knocks 96 Prints –
Dent 3/8 = X 1/16 1/4 off feed line –

199 = Hollow in Repair spot = 107 prints.
small – – Discard =
Day & night discard of 11th Aug
23?

Aug 6/16

Examination of Discarded Moulds

1 = Plateing - dirt on celluloid
2 Big piece blank & dented mould
3 Pin dropped on mould, also scratches.
4 Deep sharp dent copper, Cu flowed, dent by hard metal chip
5 Dent due to chip. near feed line
6 Dent, a chip varnished over
7 Dent
8 Crackly surface 31 prints - Condensite probably bad
9 Dent 3/8 from feed line - bridge walls scored by chip movement flowing
10 Dent 3/8 from feed line
11 Dent. 3/8 " also scratch
12 Dent 3/16 " 3 point chip -
13 Hole 1/8 from feed. sharp edges - looks like bubble in plateing
14 Mechanical injury Cu flowed, looks like piece of grit forced in Matrix. Cu flows longer than wide, has small dent in another part of mould.
15 3/4 from feed line. piece sand forced in Copper
16 3/8 from feed long chip 3/8 x 032 forced into record, found record no var on chip pressing in chip forced excess var to, sides of chip made it more shiny Needle drawn over cuts chip but not record - Dented Matrix.
17 = Report says Rough Crackly - really OK only a Run Out
18 Porous spot marked - Matrix shows serious injury except little rough spot which caused pull outs in Record - Put it back with required spot to be burnished so as to prevent pull outs
19 = Marked Rough Crackly - No so - good Mould should never have been discarded
20 - Bruise caused by piece sand 016 dia
21 = Marked Cracks - 154 prints, its good mould yet & should be put back lots of moulds need running are much worse
22 Dents in blank 2 places 3/4" apart Chip on blank or between blank
23 - Mechanical injury this shape - Symetrical shape

[169]

24 = 146 Records = pulled off too soon only 2 light snaps noticeable or could be repaired. The others not strong

25 - Reported Rough + Crackly — Not so — good mould 2 Snaps due to pieces condensite sticking to mould, this matrix was never examined + if chips removed is OK

26 Repld Rough + Cracks — Its a fine mould, not rough or any cracks noticeable — should be put back

27 - Reported Surface + Cracks — Surface good — one group of snaps which can be repaired + mould put back

28 = Repld Surface + Knocks — Surface good, only pair of knocks in record + not on mould — should be put back

29 = Repld Scratches + Cracks — only 2 Cracks in a repair spot Scratches about groove should not have been discarded 156 Records — Chip pressed in middle of mould

30 = Repld Cracks — No Cracks — just a very light run out 146 record should not have been discarded

31 = Repld Hard ambalance in blank — Couldnt find it — properly discarded

32 - Repld 3 dents — There are 5 in a group very small — 1/4 to 3/8 from feed line 015 each only gives light dull knocks — (only) record Even if weaker record it could have been repaired + put back

33 = Repld Dent = Dent sounds very weak, I could hardly hear it should go back on board again

34 = Repld Dent = Cant say if it can be repaired — 1/8" from feed line

35 = Repld Rough Surface = Has run out due to grinding Sub-machine wrong — Rightfully discarded

36 = Reptd Rough Surface — 1st print has slight Run Out 3rd print absolutely OK.

37 = Reported Buckle = Assembler left lot pieces in — Clancys fault.

38 = Reptd Dents — Discard — OK

39 = Reptd Dent from Chip = OK = Big chip in second, Chip angle of 30° 1/16 wide 1/4" long 1/8 from feed line

40 = Reptd Dent in separator opat, Discard OK — 3/8 from feed line = 3/32 Dia round

41 = Reptd Dent = 1 1/4" from feed line 020 wide 3/8 long slight angle from parallell The dent is too weak to discard mould —

42 — Discarded for 2 black holes — holes in mould — filled with Condensate sticking up felt with finger — Discarded OK

43 = Reptd Buckles — Dirt on holder Clancys fault.

44 = Reptd buckles Dirt on holder Clancys fault but sound too weak to warrant discard — 4 pcs

45 = Reptd Deep holes 72 prints — Discarded OK

46 = Nothing on Card — Hole produced by piece sand 020 —

47 — Reptd bruise = Middle of music 028 dia Slightly Dec

48 = Reptd Cracks 133 prts = Chip in second 1/8 from feed line should have been discarded for Dent moulds has Crackly surface

See back

11 pages

Examinations for density, as shown between on Record

1 – Fibre-bag
2 Water spot
3 " "
5 Red, wet spot
6 grafite, wet + black
7 Wad of pure grafite
8 Water Spot
9 Portland Cement
10 Water Spot
11 "
12 fibre from bag

Moulds not required

Girls employed Disc Dept
214 mostly 15c some 17½

Varnish	59
Oil Hanks	6
Printing	1
Sorting & cards	5
Eye Inspect	8
Machine test	6
Edge Inspect	4
Mould test	9
Numbering, Sorting	11
Final-Wrap-Inspect	60
PB Inspector	6
Matrons	3
Office	5
	183

Mould Repair room	21
Celluloid Pressing "	5
" Dip "	4
Clerk	1
	31

	Discard Dents	Many Cracks	Record per Mould
July 25	35	41	105
26	38	27	87
27	43	19	100
28	60	23	90
29	56	29	83
31	17	23	101
Aug 1	78	49	82
2	37	47	99

Inspectors Reports

July	Comcl	Perfect	Ven Pullout	Rounds	New M Rec	New M Bad	New M %
19	92	66.9	15%	20	20	none	
20	88	63.2	17	20	50	"	
21	93.9	66.8	14	50	95	"	
22	93.3	56.6	20	40	70	1	
24	89.57	55.3	37.5	60	102	2	
25	90.27	59.2	34.5	60	104	1	
26	86.8	48.7	39.1	60	105	4	
27	92.6	58.6	34.3	60	127	6	
28	93.4	59.5	33.6	60	145	3	
29	94.6	56.3	26.5	55	111	0	
31	93.1	56.7	34.5	60	132	2	18%
Aug 1	90-	70.67	23.19	60	242	1	33%
2	93.6	70.5	22	60	201	2	27%
3	89.9	58.2	30	60	146	7	22%
4	90.8	50.5	30	60	183	4	25.4
5	91.36	57.74	30	51	193	1	31%
7	93.4	62.6	28	60	236	2	
8	92.5	46.1	46	60	281	11-	39%
9	91	67.6	26	60	337	5	46
10	92..	56-	30-	60	322	6-	44
11	93.6	48.6	40	60	365	5	50
12	94.1	46.1	44	60	297	5	40
14	93.9	51.	40	60	374	2 Dia Ven 6 Com- "	50%
15	95-	49	45	40	281	2 Dia Ven	50
16	91.6	41	30%		115	00	24%
17	91	53.5	30-		225	1 Ven 1 Dia	47

Drop Test.

July 11	12-6-9-4-8-6	45	
12	20-4-6-5-10-20	65	
13	2-8-17-2-13-13	55	
14	15-5-5-8-1-9	43	
15	2-20-20-8-2-20	72	
17	20-10-20-1-20-19	90	
18	9-18-3-20-12-1	63	
19	12-7-19-20-2-10	70	
21	20-3-1-9-13-7	53	
22			
23			
24	8-14-20-2-5-20	69	
25	20-3-12-20-4-9	68	
26	10-11-9-5-7-20	62	
27	20-15-8-3-20-20	86	
29	18-7-20-10-3-20	78	
Aug 1	20-20-2-14-18-20	94 x	x Excess of new Mixed Hands
2	13-3-3-5-3-7-	34	
3	9-2-7-2-20-6-	46.	
4	16-7-2-19-20-18	82	
5	20-20-20-20-3-3-	86	
7	18-20-7-20-13-20-	98	
8	10-18-3-1-20-16-	68	
9 =	3-7-18-20-13-9-	70	
10 =	7-19-20-20-20-13-	99	
11	18-3-20-10-9-16-	76	
12	20-10-9-3-19-16-	77	
14	12-20-20-7-18-16-	93	

Blanks made

July	19	15371
	20	14747
	21	
	22	
	23	
	24	9378
	25	12755
	26	14350
	27	14659
	28	16473
	29	14691
	31	12612
Aug	1	16245
	2	16296
	3	17343
	4	17635
	6	15256
	7	16209
	8	18039
	9	14248
	10	
	11	
	12	
	13	
	14	
	15	
	16	
	17	18174
	18	19220
	19th	9107
	21	13390
	22	13706
	23	13146
	24	10254
	25	11312
	26	7822
	28	15602
	29	17066
	30	17594
	31	17741
Sept	1	15126
	2	{Shut down. Saturday}
	5	15626
	6	16514
	7	17183
	8	13076
	9	7914
	11	18314
	12	19478

Record to Baldwin

June 20	7651	July 22	5427	21st 8150 - Nov 6	
21	5571	24	5089	22	9391
22	6247	26	5587	23	10772
23	3968	27	3898	24	11054
24	5230	28	5256	25	12097
26	7166	29	5236	26	11073
27	8838	31	4481	28	11442
28	8465	Aug 1	5978	29	10785
29	9638	2	6117	30	13334
30	10169	3	6161	31	10807
July 1	9285	4		Sept 1	11822
3	9562	5		2	9548
5	9101	7	5579	5	12057
6	9055	8	6247	6	10746
7	9133	9	7125	7	13395
8	7105	10	8089	8	10642
10	9031	11	9287	9	10041
11	6066	12	8126	11	10605
12	7149	14	9309	12	13128
13	6137	15	10065	13	11994
14	7639	16	10071		
15	5080	17	10075		
17	7006	18	8881		
18	4132	19	10696		
19	5127				
20	5138				
21	2797				

New Mould holes
used by Clancy

old rings I turned down
so can use without lead

July 1	8			
3	5			
5	14			
6	10			
7	14			
8	10			
11	12			
12	13			
14	9			
19	26			
20	15			
21	15			
22	14			
25	12			
26	24			
27	23			
28	19			
29	11			
31	—			
Aug 1	24	Total 263		
2	51	314 — Clancy says	344 + may have few more	
3	43		387	31%
4	41		428	34.2
5	26		454	
7	33		487	38.8 %
8	50		537	43%
9	42		579	46.3
10	38		617	50%
11	51		668	53.4
12	21		689	55.2
14	43		732	44

Reee 18 book

10811) 80520 (7.4.4
75677
48434
43246
5188

8848
936
53088
26544
79632
82817
10811 —

8281
229
8052

5156
3683
9
8848

34
540
136
10
17
18,3
8579
38
617

18300
95
1500
1500
12810
1371

275
579
854

Aug 2/16
Blank Schedule

5 min Contact
3 " 600 Lbs
8 " Cool-

[ITEM(S) FOUND IN BOOK]

June 19. 1916

Mr. Edison,

Sir,

Would you be disposed to give me an increase in my salary, At my age and with my experience I feel that I ought to be earning more than I at present receive. Perhaps, when you take into consideration the fact that I have been in your employ four years you will not think this an unreasonable request, and be inclined to grant it. I need not say that in any case, while I remain with you, my best energies will continue to be as they have hitherto been, devoted to your interests.

I remain
Yours obediently
J. Miller

[ITEM(S) FOUND IN BOOK]

Mr Edison I laid out
Four diff style Automatic Varnishing
Machines the last is very simple
and will not cost much to make
up using all the parts of Hand
Varnishing Machines, One Girl
can turn out 2.100 in ten hours
easy, I think 7 of these Machines
will give an output of 15,000 Disk

June 26. 1916

J F Ott

[ITEM(S) FOUND IN BOOK]

Mr Edison

[ITEM(S) FOUND IN BOOK]

September 12th, 1916.

Mr. T. A. Edison,

13128 - #1522 Brushed Blanks delivered to stock.

Rejected - New Process

Spots	11	
Scratched	51	
Cracked Edge	1	
Chipped Edge	21	
Poor Print	2	
Bad Centers	3	
Cracked Centers	1	
Wrong Combination	7	
	97	Total.

GHB/AMO.

G.H.Baldwin

[ITEM(S) FOUND IN BOOK]

September 13th, 1916.

Mr. T. A. Edison:-

11994 - #1522 Brushed Blanks delivered to stock.

Rejected - New Process

Spots	12
Scratched	32
Dents	1
Chipped Edge	4
Pin Holes	1
Bad Centers	7
Cracked Centers	1
Wrong Combination	1
Powr Print	2
	61 Total

G.H.Baldwin.

GHB/AMO.